

Work Order ID 68221

Friday, April 08, 2011 3:01:35 PM



Page 1

Item ID: DSI 9464-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Tuning

Start Date: 4/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-04-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

DSI 9464

B

100

0.00



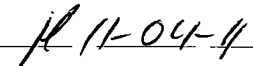
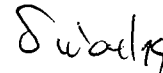
DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

0.00



110

Pick Kit

0.00

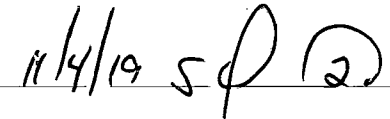


Packaging

Memo

0.00

Packaging



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 68221

Friday, April 08, 2011 3:01:35 PM



Page 2

Item ID: DSI 9464-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Tuning

Start Date: 4/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

130

Memo
Identify and pack for shipping as per PPP DSI 9464-011
Location: 20
PPP rev: A

0.00



Packaging

Packaging

0.00

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11 SP 20

11/4/11 JF
MR
11-04-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Friday, April 08, 2011 3:01:41 PM

Page 1

Work Order ID: 68221

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning



Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-553 DD 10.04.19 verified byEC

IPP Rev:B as

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|---------|
| S ₇₂ D3955-041 Doubler Assembly | | Manufactured | No | | | 110 | Each | 1.0000 | 2 | 4 | | | (3x) SP |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST098 | | | 1 | | | | | | |
| | | | | 67406 | | | 1 | | | | | | |
| S ₇₂ D3955-3 Cover Plate | | Manufactured | No | | | 110 | Each | 2.0000 | 2 | 4 | | | SP |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST097 | | | 2 | | | | | | |
| | | | | 67407 | | | 2 | | | | | | |
| S ₇₂ D3955-5 Plate | | Manufactured | No | | | 110 | Each | 1.0000 | 2 | 4 | | | SP |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST098 | | | 1 | | | | | | |
| | | | | 67408 | | | 1 | | | | | | |
| S ₇₂ D3955-7 Plate | | Manufactured | No | | | 110 | Each | 0.0000 | 6 | 12 | | | SP |
| S ₇₂ D3955-21 Gasket | | Manufactured | No | | | 110 | Each | 14.0000 | 2 | 4 | | | SP (20) |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST098 | | | 14 | | | | | | |
| | | | | 67410 | | | 14 | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, April 08, 2011 3:01:41 PM

Page 2

Work Order ID: 68221

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3955-23

Manufactured No

110 Each

4.0000

2

4



Template

Location

Loc Qty

Loc Code

ST097

4

67411

4

CR3212-4-04

Purchased

No

110 Each

673.0000

38

76



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

673

113749

73

115698

200

116471

400

AN3-5A

Purchased

No

110 Each

512.0000

4

8



Bolt

Location

Loc Qty

Loc Code

ST350

512

115371

500

116632

12

AN3-6A

Purchased

No

110 Each

186.0000

4

8



Bolt

Location

Loc Qty

Loc Code

ST351

186

114941

36

116191

50

116704

100

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, April 08, 2011 3:01:42 PM

Work Order ID: 68221

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN3-7A

Purchased

No

110

Each

100.0000

4

8



Bolt



11/4/11

Location

Loc Qty

Loc Code

ST351

100

117313

100

AN3-10A

Purchased

No

110

Each

128.0000

4

8



Bolt



8

Location

Loc Qty

Loc Code

ST351

128

116400

28

117313

100

NAS1149D0332J

Purchased

No

110

Each

3,157.0000

6

12



Washer



11/4/11

2

Location

Loc Qty

Loc Code

FP-B

156

117010

156

ST297

2000

117087

2000

ST298

1001

117010

1

117291

1000

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 68221

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning



Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

1,987.000

2

4



Nut



11/4/11

21

Location

Loc Qty

Loc Code

ST300

1987

116391

413

116540

800

116549

774

y

Friday, April 08, 2011 3:01:42 PM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skidtube in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skidtube.

Procedure:

Note: Installer must be careful not to damage underlying skidtube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skidtube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skidtube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skidtube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skidtube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skidtube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:





The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

| | | | |
|------------|---|--|--------------|
| B | ADD REF TO D204-635 | CP | 10.04.14 |
| A | NEW ISSUE | RF | 09.07.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. |  | DSI 9464 | SHEET 1 OF 3 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | | SKIDTUBE TUNING KIT | NTS |
| DATE | 10.04.14 | COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

REFERENCE ONLY

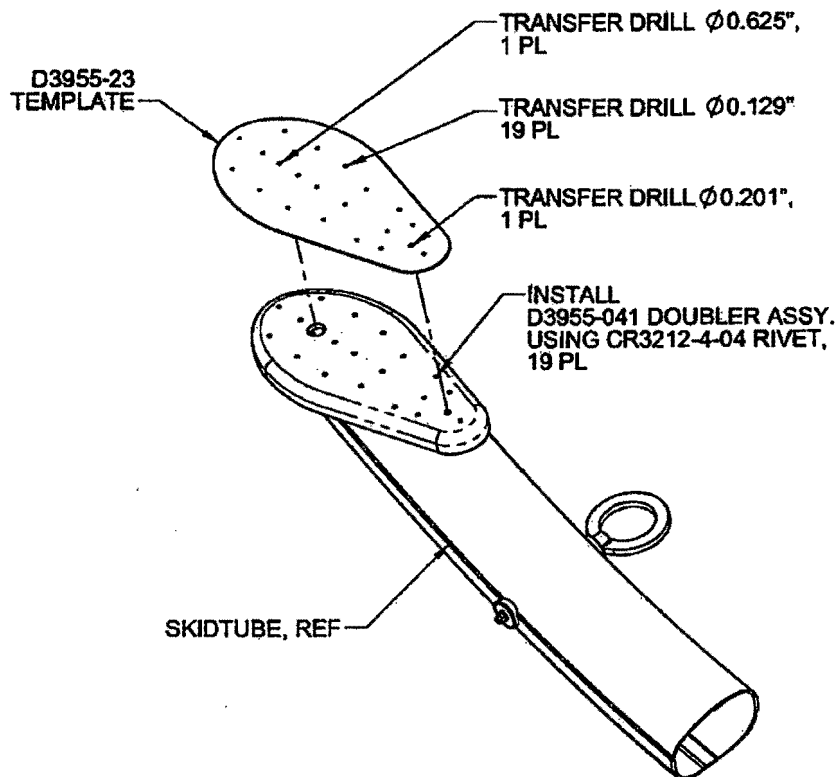





Figure 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

| | | | |
|--|---|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9464 | SHEET 2 OF 3 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | SKIDTUBE TUNING KIT | NTS |
| DATE | 10.04.14 | COPYRIGHT © 2009 BY DART AEROSPACE LTD | |
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REFERENCE ONLY

Part List

| Qty -011 | Part Number | Description | Weight |
|-------------|---------------|---------------------|------------------|
| X | DSI 9464-011 | SKIDTUBE TUNING KIT | N/A |
| 2 | D3955-041 | DOUBLER ASSEMBLY | 0.25 lb/ 0.11 kg |
| 2 | D3955-3 | COVER PLATE | 0.64 lb/ 0.29 kg |
| 2 | D3955-5 | 0.063" THICK PLATE | 0.64 lb/ 0.29 kg |
| 6 | D3955-7 | 0.125" THICK PLATE | 1.28 lb/ 0.58 kg |
| 2 | D3955-21 | GASKET | 0.08 lb/ 0.04 kg |
| 2 | D3955-23 | TEMPLATE | N/A |
| 38 | CR3212-4-04 | RIVET | N/A |
| 4 | AN3-5A | BOLT | N/A |
| 4 | AN3-6A | BOLT | N/A |
| 4 | AN3-7A | BOLT | N/A |
| 4 | AN3-10A | BOLT | N/A |
| 6 | NAS1149D0332J | WASHER | N/A |
| 2 | MS21042L3 | NUT (OR MS21042-3) | N/A |

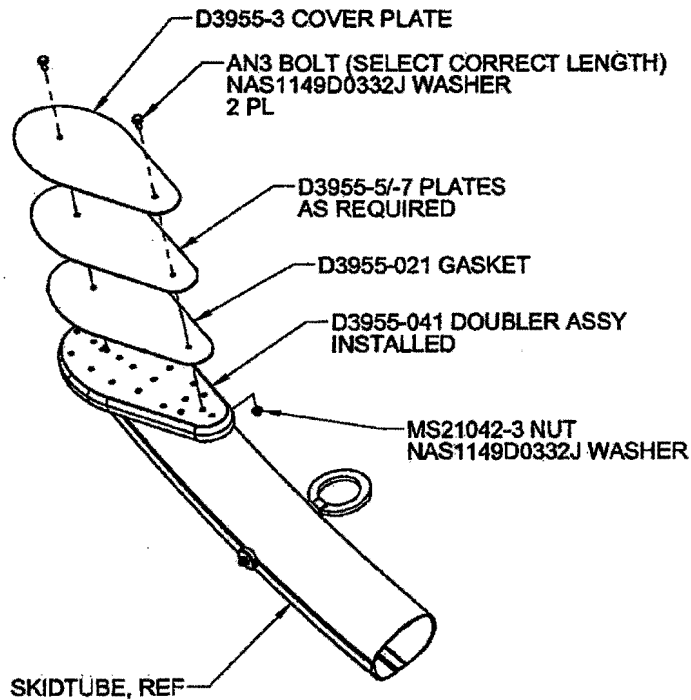


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | DSI 9464 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SKIDTUBE TUNING KIT | NTS |
| DATE | 10.04.14 | COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

